

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021801**Date Inspected:** 09-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019AZ

Weld No: 250

Welder: 066733

WPS-B-T-2233-ESAB

PCMK: SA-3013-001

Weld No: 010

Welder: 051356

WPS-B-T-2232-ESAB

PCMK: SEG-3007AH

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Weld No: 039, 087, 097, 107, and 117

Welder: 055491

WPS-B-T-2231-ESAB

PCMK: SEG-3007AH

Weld No: 061, 089, 099, 109, and 119

Welder: 050242

WPS-B-T-2231-ESAB

PCMK: SEG-3007Q

Weld No: 326

Welder: 055564

WPS-B-T-2233-ESAB

PCMK: SEG-3007S

Weld No: 233

Welder: 055564

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019Z

Weld No: 013 and 015

CWR: 2755

Welder: 215553

WPS-345-SMAW-2G(2F)-FCM-1

PCMK: SEG-3019Z

Weld No: 012

CWR: 2755

Welder: 050969

WPS-345-SMAW-2G(2F)-FCM-1

PCMK: SEG-3019AA

Weld No: 028

CWR: 2755

Welder: 216086

WPS-345-SMAW-2G(2F)-FCM-1

PCMK: SEG-3019M

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Weld No: 256~259
Welder: 044779
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019P
Weld No: 236~245
Welder: 054013
WPS-B-P-2213-TC-U4b-FCM-1

PCMK: SEG-3019AQ
Weld No: 039, 043, 046, and 057
Welder: 044779
WPS-B-P-2214-TC-U4b-FCM-1

PCMK: SEG-3007 DP to DP
Weld No: 007
Welder: 037748
WPS-B-P-2213-B-U2-FCM-1

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W5-SB33-001
Weld No: 126~131
Welder: 053753
WPS-B-P-2112-FCM-1

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB18A-001
Weld No: 050
Welder: 201074
WPS-B-T-2132-ESAB

PCMK: E5-SB25A-001
Weld No: 126~131

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Welder: 222396
WPS-B-T-2132-ESAB

PCMK: W2-SB27-001
Weld No: 019
Welder: 062092
WPS-B-T-2232-ESAB

PCMK: E2-SB24B-001
Weld No: 126~131
Welder: 048625
WPS-B-T-2132-ESAB

PCMK: E2-SB25C-001
Weld No: 048
Welder: 201889
WPS-B-T-2132-ESAB

PCMK: E5-SB25D-001
Weld No: 001~012
Welder: 201074
WPS-B-T-2132-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SA-6029-001
Weld No: 039
Welder: 062807
WPS-B-T-2232-ESAB

PCMK: SA-6529-001
Weld No: 040
Welder: 062883
WPS-B-T-2232-ESAB

PCMK: SA-6531A-001
Weld No: 041
Welder: 058792
WPS-B-T-2232-ESAB

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PCMK: SA-6531A-001

Weld No: 013

Welder: 062806

WPS-B-T-2232-ESAB

PCMK: SA-6530-001

Weld No: 040

Welder: 062749

WPS-B-T-2232-ESAB

PCMK: SA-6030-001

Weld No: 013

Welder: 067806

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Heat Straightening process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Heat Straightening Procedure Specification (HSR). Listed below are the locations that were identified by this QA inspector.

PCMK: BK-004A-014

HSR-1(B)-9501

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Rice,Brett	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
